

Work Order ID 52261

September 22, 2009 7:41:48 AM

Derek
74805



Page 1

Item ID: D412-694-02

Revision ID: C1

Item Name: Door Assembly

Start Date: 9/22/09 Start Qty: 1.00

Required Date: 11/13/09 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: CY

QC:

Date: 09/09/22 Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D412-694

Rev C1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Issue red decal labels for D412-694-02. CHG005

110

0.00



COMPOSITE ASSEMBLY

Small Fab

Memo

0.00

Small Fab

D412-694-02 Drill Process 11- D412-694-02 Drill Process Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-02 as per Dwg D412-694 page 4 (view P). 1-2- Open (1) hole to 11/16" (0.688) for the

09-11-30

120

0.00



COMPOSITE ASSEMBLY

Small Fab

Memo

0.00

Small Fab

1- Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q). 12- Sand flush excess Hysol around the insert on both doors.

09-11-30

Hysol 934

M 113022

W 113118 09-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D412-694-02

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Door Assembly

Start Date: 9/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

> 8 or 10/3



QC

Memo

0.00

Quality Control

Inspect that inserts are flush with the surface.



140

COMPOSITE ASSEMBLY

0.00



Small Fab

Memo

0.00

Small Fab

1. Apply Primer filler and reducer around the inserts on both doors. I A/R

11045 Primer Filler

Batch: 112384 I A/R

12375S Reducer

Batch: 12960

87 09-12-02

150

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

11 09 12 03

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Small Fab

Small Fab

COMPOSITE ASSEMBLY

Memo

0.00

D412-694-02 Assembly Process[1]- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes. [1]Note: Start installation window side. Wait to fix D316



ET 10-01-06

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00



100106

180



Small Fab

Small Fab

COMPOSITE ASSEMBLY

Memo



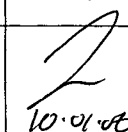
0.00

D412-694-02 Assembly Process (Continued): 1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N). [1]Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door. [2]- Install

ET 10-01-06

W/O: 52261		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-694-02 PAR #: N/A Fault Category: Composite ^{5m Job} NCR: Yes No DQA: 1 Date: 11.10.07
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 11/10/11

NCR: 11-583		WORK ORDER NON-CONFORMANCE (NCR) 31.62 x 2						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-01-06	160	install rivet MS 20426AD4-3 squished improperly upon drilling out rivet to install new bracket bent x 2 route cause rivet too short RC: Process		scrap + replace longer rivet rivet MS 20426AD4-3 m 12655 x 4 bracket 3156-1 m 50297 x 2	RT 10-01-06			

NOTE: Date & initial all entries

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Stop

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Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

100106

200

COMPOSITE ASSEMBLY

0.00



Small Fab

Memo

0.00

Small Fab

1- Finish installing D3163-042 in the door. 12- Install red decal before closing cover.

ET 11-09-30

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Install door on mock up helicopter to insure proper fit and function.

108 11-09-30

W/O:		WORK ORDER CHANGES					
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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PP

52260

11/10/5

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/5
MF 11-10-5

W/O:		WORK ORDER CHANGES					
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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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NAS43DD3-14



Spacer

Purchased

No

120

Each

67.0000

6.0000



RT 09-12-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

67

19347

67

B113368

80-005-2-8



Insert

Purchased

No

160

Each

147.0000

55.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

147

112439

20

19443

127

M 3109

M1128 30 SL
↓

47x8

AN525-10R6



Screw

Purchased

No

160

Each

210.0000

12.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

210

101203

210

12x51

9/11/12 3 SL @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN525-10R7  Screw		Purchased	No			160	Each	163.0000	8.0000			9/14/03 SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	163	
106166	30	
110844	15	
112314	18	
112411	100	

AN960JDT0L  Washer		Purchased	No			160	Each	6,445.000	18.0000			9/14/03 18x50
---	--	-----------	----	--	--	-----	------	-----------	---------	---	--	---------------

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	6445	
101291	16	
104885	153	
105793	236	
109632	1040	
110985	5000	

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Page 2

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Start Qty: 1.00

Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10LL  Washer		Purchased	No			160	Each	4,077.000	15.0000			

9/11/23 54

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 4077
19085 376
19600 3701

AN960JD416L  Washer		Purchased	No			160	Each	958.0000	6.0000			
--	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

15x50

9/11/23 1050

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 958
107008 54
108138 4
108583 42
110153 458
112492 400

6x50

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 52261

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Comments:

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960J08

Purchased

No

160

Each

1,775.000

6.0000



Washer



9/11/23 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1775

107091

9

108335

11

110382

48

110917

3

111578

404

112314

500

112385

800

6x50

BSP45

Purchased

No

160

Each

270.0000

79.0000



Commercial Rivet



9/16/23 WSP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

270

107296

270

11821

0

11/27/94 sl

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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BSP46-



Commercial rivet

Purchased

No

160

Each

412.0000

6.0000



9/11/23 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

412

101237

112

112540

300

14230

0

6x50

D3110-5RevC



Handle Assembly

Manufactured

No

160

Each

2.0000

1.0000



B53739 9/11/23 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

27081

1

50427

1

D3115-1RevB



Bracket

Manufactured

No

160

Each

9.0000

1.0000



9/11/23 R SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

36152

3

50355

6

178

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Page 5

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~~D3116-7RevA~~



Seal

Manufactured

No

160

Each

69.3334

5.6666



9/11/23 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

69.3334

27239

69.3334

1xSP

~~D3116-9RevA~~



Seal

Manufactured

No

160

f

534.5000

6.4166



9/11/23 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

534.5

17463

6.5

39182

528

1xSP

~~D3121-041RevE~~



Bracket Assembly

Manufactured

No

160

Each

2.0000

3.0000



350441 9/11/23 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

39183

2

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3121-044RevE

Manufactured

No

160

Each

6.0000

1.0000



Bracket Assembly

9/11/23 SF

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

24678

1

24699

2

28718

3

1x50

D3122-1RevC

Manufactured

No

160

Each

9.0000

1.0000



Lever

9/11/23 SF

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

9

25539

1

44541

8

24339 50

D3123-1RevC

Manufactured

No

160

Each

228.0000

2.0000



Cam

9/11/23 SF

(N)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

228

1053617

228

2454

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D3124-1RevB 		Manufactured	No			160	Each	88.0000	1.0000			
Hook												

9/11/23 SP

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

88

1053617

88

D3124-2RevB-1

Manufactured

No

160

Each

84.0000

1.0000

Hook

1x SP

9/11/23 SP

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

84

1053617

84

D3126-1RevA1

Manufactured

No

160

Each

12.0000

1.0000

Bracket

1x SP

9/11/23 SP

(1x)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

12

41929

12

1x SP

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3126-3RevA1		Manufactured	No			160	Each	13.0000	1.0000			
												
Bracket												

9/11/23 SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

13

28105

13

1x SP

D3126-3RevA1

Manufactured

No

160

Each

52.0000

5.0000



Bracket

9/11/23 SP

9/11

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

52

1053617

2

36729

12

50345

38

1x SP
1x SP
4x SP

D3132-042RevB

Manufactured

No

160

Each

36.0000

1.0000



Rod Weldment

9/11/23 SP 10

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

36

1053617

36

1x

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3133-041RevB Manufactured No



Rod Weldment

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

21

1053617

21

D3135-041RevD Manufactured No



Handle Weldment

D3137-045RevF Manufactured No



Bracket Assembly

D3138-2RevC Manufactured No



Cover

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1

24341

1

Main Warehouse

ST241A

2

50584

2

10-01-06
RT

1x50

32370 sl

52371 9/11/23 sl

9/11/23 sl

1x50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3139-1 RevB		Manufactured	No			160	Each	29.0000	1.0000			
												
Guard												

9/11/23 sl

Warehouse
Location

Main Warehouse

ST

29

24700

29

~~D3139-1~~ RevB

Manufactured No

160

Each

9.0000

1.0000



Guard

1x Sl

9/11/23 sl

Warehouse
Location

Main Warehouse

ST

9

24700

9

~~D3140-06~~ RevF

Manufactured No

160

Each

0.0000

1.0000



Door

1x Sl

CB 52261 C2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3144-111RevA		Manufactured	No			160	Each	11.0000	2.0000			
Spring												

9/11/23 SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 3

34725 1

50302 2

Main Warehouse

ST067 8

50302 8

1x SP
1x

D3144-111RevC

Manufactured No

160

Each

0.0000

1.0000



Doubler

D3144-111RevC

Manufactured No

160

Each

3.0000

1.0000



Doubler

32372 9/11/23 SP
9/11/23 DSE

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 3

22021 3

1x SP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 13

Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3144-123RevC  Doubler		Manufactured	No			160	Each	4.0000	1.0000			

9/11/24 sf

Warehouse Loc Qty Loc Code

Location

Main Warehouse


ST

4

22025

4

1x50

D3144-13RevC  Doubler		Manufactured	No			160	Each	9.0000	1.0000			
---	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

9/11/24 sf

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

9


21911

1

24723

8

1x2

D3148-1RevB  Clevis		Manufactured	No			160	Each	184.0000	2.0000			
---	--	--------------	----	--	--	-----	------	----------	--------	--	--	--

9/11/23 sf

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

184

1053617

184

2x50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3151-041RevC		Manufactured	No			160	Each	12.0000	1.0000			
												
Doubler Assembly												

9/16/09 sl

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

12

39186

4

50294

8

D3152-042RevB

Manufactured

No

160

Each

5.0000

1.0000



Bracket Assembly

9/16/09 sl

9/16/09 sl

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

5

25285

5

D3155-041RevD

Manufactured

No

160

Each

5.0000

1.0000



Bracket Assembly

9/16/09 sl

9/16/09 sl (10)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

5

27178

5

9/16/09 sl

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09

Required Date: 11/13/09



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3155-042RevD  Bracket Assembly		Manufactured	No			160	Each	7.0000	1.0000 		9/11/09 sf	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7	
24343	3	
26933	4	

1x sf

D3156-1RevB  Bracket		Manufactured	No			160	Each	14.0000	2.0000 		9/11/09 sf	
--	--	--------------	----	--	--	-----	------	---------	---	--	------------	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
24772	2	
Main Warehouse		
ST068	12	
50297	12	

2x sf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3162-041RevC1 Manufactured

No

160

Each

37.0000

10.0000

9/11/23 sld



Bracket Assembly

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

st073

37

50370

37

1x sld

D3162-043RevC1 Manufactured

No

160

Each

10.0000

1.0000

9/11/23 sld



Bracket Assembly

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST

10

24491

1

36949

9

1x sld

D3162-044RevC1 Manufactured

No

160

Each

17.0000

1.0000

9/11/23 sld R



Bracket Assembly

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST

17

36734

17

1x sld

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3163-042RevD 		Manufactured	No		9/11/23	160	Each	0.0000	1.0000	39	9/22/09	SL
Cover Assembly D3183-042RevC1 		Manufactured	No			160	Each	6.0000	1.0000		9/11/23	SL
Bracket Assembly												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

36736

1

50253

5

D3203-1 RevC



Handle

Manufactured No

160

Each

15.0000

1.0000



1x50

9/11/23 SL

R

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

48565

15

1x50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3308-1RevA



Doubler

Manufactured

No

160

Each

4.0000

2.0000



9/11/24 SP

B52028 SD

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

4

39187

4

2 SD

M7885/2-4-3



Rivet

Purchased

No

160

Each

576.0000

12.0000



9/11/23 SD

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

576

107376

576

12x SD

M7885/3-4-4



Rivets

Purchased

No

160

Each

278.0000

12.0000



9/11/23 SD (12)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

278

104625

100

108077

178

12x SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20392-2C17		Purchased	No			160	Each	198.0000	2.0000			
												
Pin												

9/16/23 sf

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

198

18949

198

250

MS20392-2C9

Purchased

No

160

Each

17.0000

2.0000



Pin



9/16/23 sf

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

17

11784

17

250

MS20392-3C215

Purchased

No

160

Each

26.0000

2.0000



Pin



9/16/23 Dsf

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

26

104156

26

2xsf

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-3		Purchased	No			160	Each	7,353.000	8.0000			
												
Rivet												

9/11/23 sf

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 7353

1563 0

19099 4776

7681 2577

MS20426AD4-5	Purchased	No				160	Each	7,926.000	4.0000			
												
Rivet												

8x50

9/11/23 Dsf

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 7926

4067 1109

6733 1835

6874 4982

4x50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-6 		Purchased	No			160	Each	4,094.000	4.0000			
Rivet											9/11/03	SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	4094
100151	27
103395	14
105144	252
110139	3774
2525	27

MS21042E08



Nut

Purchased

No

160

Each

347.0000

6.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST	347
110002	24
111889	51
112243	47
112492	125
112612	100

112796

9/11/03

SP

5x SP

1x SP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 7:41:48 AM

Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly



Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4  Nut		Purchased	No			160	Each	7,870.000	4.0000		9/16/09	SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	7870
107499	5
108145	4
110450	1
110507	184
111827	5996
112314	1615
15924	0
7690	24
8182	41

4x SP

MS24665-151



Cotter Pin

Purchased

No

160

Each

949.0000

6.0000



9/11/09 (X) SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	949
14526	70
17566	879

6x SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 7:41:48 AM

Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24693-S271  Screw		Purchased	No			160	Each	609.0000	4.0000		9/11/23	SL

Warehouse Loc Qty Loc Code
Location


Main Warehouse

ST

609

14478

609

MS24694-C57

Screw

Purchased

No

160

Each

88.0000

4.0000

4xSL

9/11/23 SL

Warehouse Loc Qty Loc Code
Location


Main Warehouse

ST

88

106815

88

MS24694-S57

Screw

Purchased

No

160

Each

613.0000

6.0000

4xSL

9/11/23 SL

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

613

18949

170

19073

443

6xSL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS24694-S50

Purchased

No

160

Each

168.0000

18.0000



Screw

9/11/23 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

168

108936

6

111020

18

112195

144

MS24694-S98

Purchased

No

160

Each

88.0000

4.0000



Screw

1112000 SP

9/11/23 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

88

111776

38

112724

50

MS27039-1-05

Purchased

No

160

Each

125.0000

2.0000



Screw

XX SP

9/11/23 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

125

3501

125

2X SP

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Page 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 7:41:48 AM

Page 25

Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly


Comments:

Start Date: 9/22/09


Required Date: 11/13/09

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-06  Screw		Purchased	No			160	Each	1,020.000	14.0000		9/11/23 SP	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1020	
104289	1000	
106815	20	

MS27039-1-08  Screw		Purchased	No			160	Each	3,333.000	13.0000		9/11/23 SP	
---	--	-----------	----	--	--	-----	------	-----------	---------	--	------------	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3333	
110467	192	
110552	1141	
110835	2000	

MS35275-233  Screw		Purchased	No			160	Each	74.0000	2.0000		9/11/23 SP	
--	--	-----------	----	--	--	-----	------	---------	--------	--	------------	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	74	
103641	20	
11822	54	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 26

Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS35649-264		Purchased	No			160	Each	59.0000	2.0000			
Nut												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

59

11822

59

MS35650-3252

Purchased

No

160

Each

54.0000

2.0000

Nut

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

54

110372

50

11735

4

MS51859-7

Purchased

No

160

Each

64.0000

3.0000

Washer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

64

111193

64

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Page 26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 7:41:48 AM

Page 27

Work Order ID: 52261

Parent Item: D412-694-02RevC1

Parent Item Name: Door Assembly

Comments:

Start Date: 9/22/09

Required Date: 11/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS43DD3-10 Spacer		Purchased	No			160	Each	75.0000	7.0000		9/16/23 @ SP	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	75	
19347	75	

7x50

PTD

September 22, 2009 7:41:48 AM

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Page 27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-01-06	160	add to pick list MS21072-L3 nut plate B 112492	ET 10-01-06				

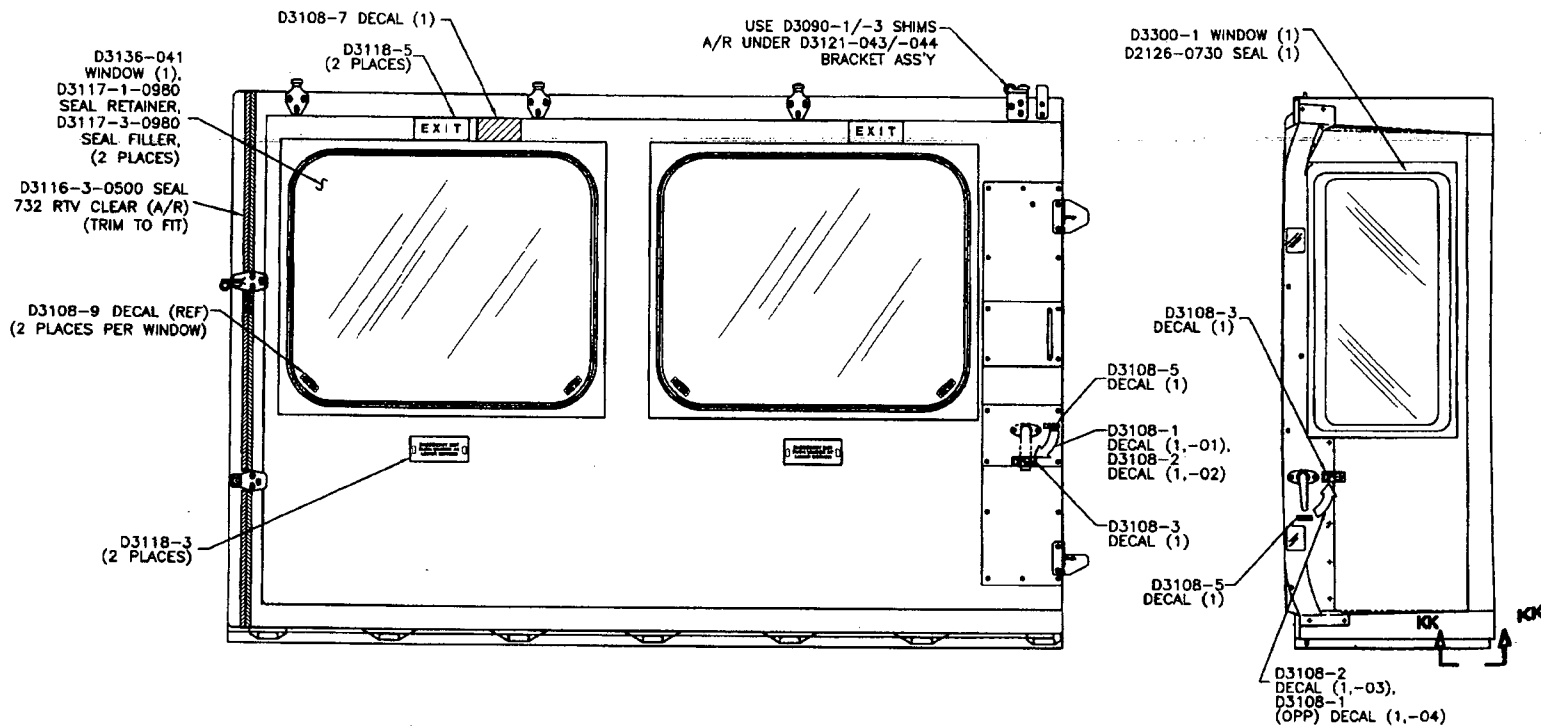
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIGURE 2: Decal Installation



D412-694-01 DOOR ASSY (SHOWN)
D412-694-02 DOOR ASSY (OPP.)
 VIEW LOOKING • INSIDE OF DOOR

D412-694-03 DOOR ASSY (SHOWN)
D412-694-04 DOOR ASSY (OPP)
 VIEW LOOKING • INSIDE OF DOOR

NOTE: THE PARTS LABELLED IN THIS DIAGRAM ARE INSTALLED BY THE CUSTOMER AFTER PAINT.
 ALL OTHER PARTS COME PRE-ASSEMBLED ON THE DOOR.

VIEW KK-KK

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 WITHOUT NOTICE
 WORK ORDER
 NO. 52261

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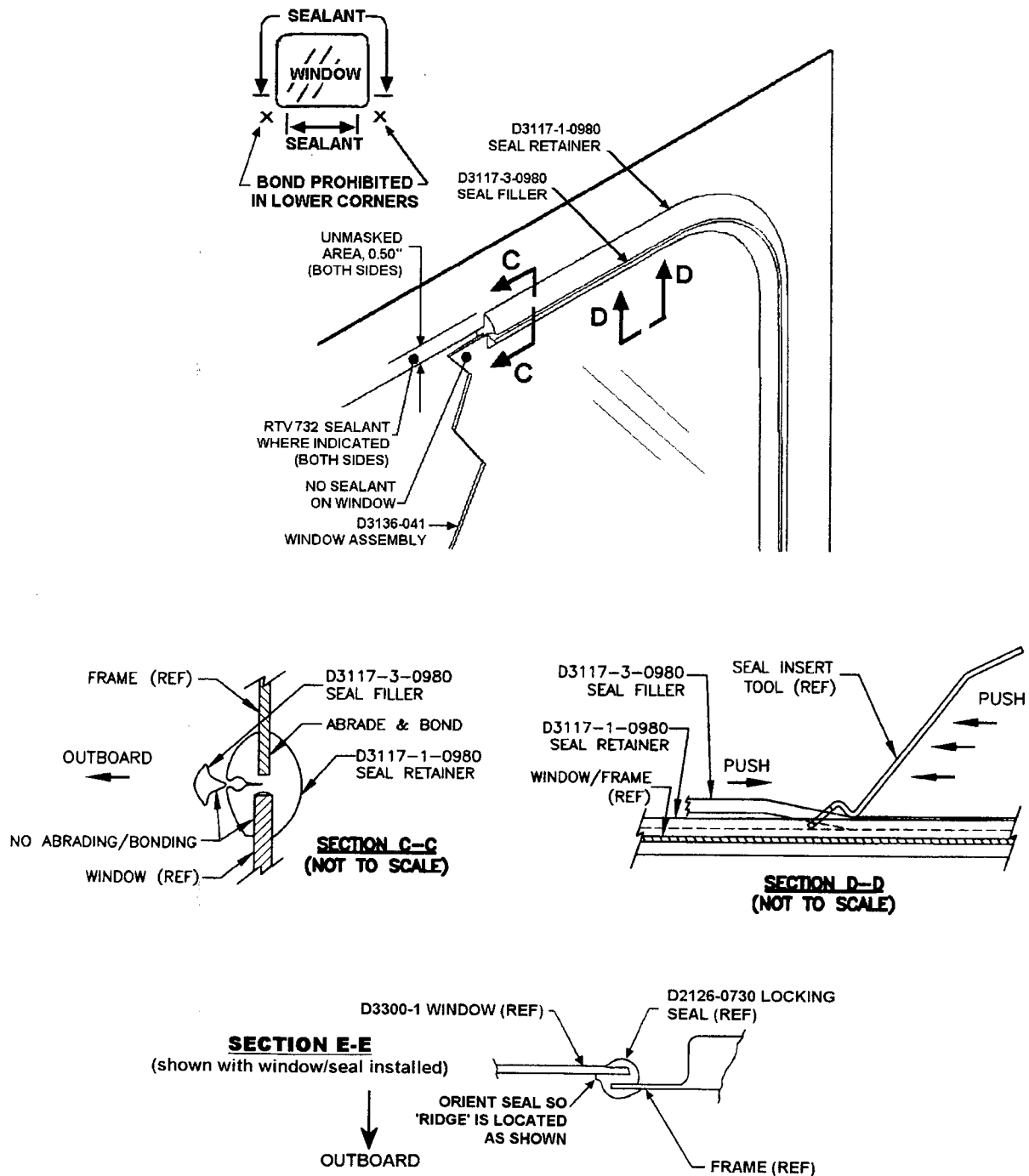


FIGURE 3: window/Seal Installation, (D412-694-01/-02 Door Assembly)

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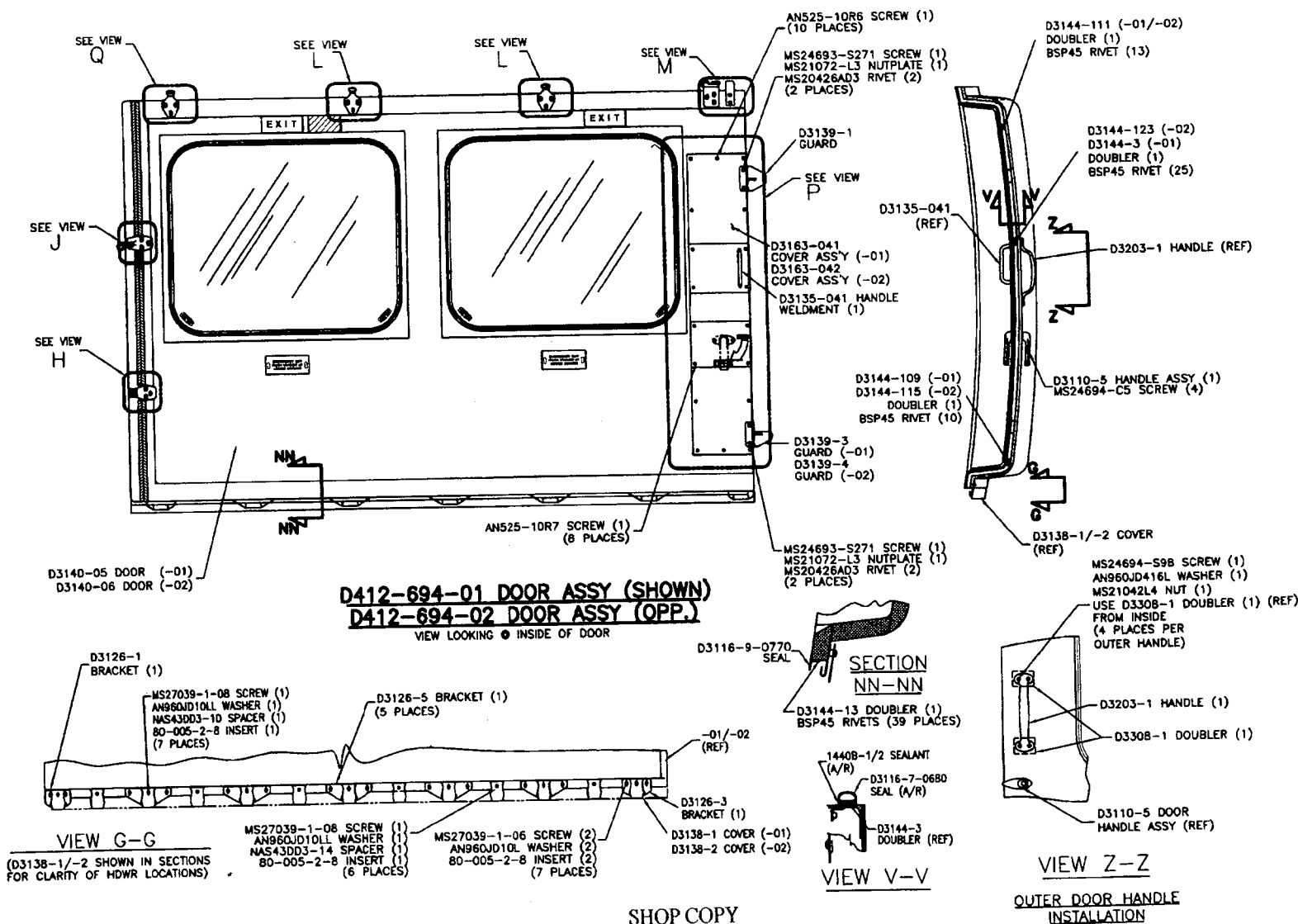
FIGURE 4: Replacement Parts: D412-694-01/-02 Door Assembly

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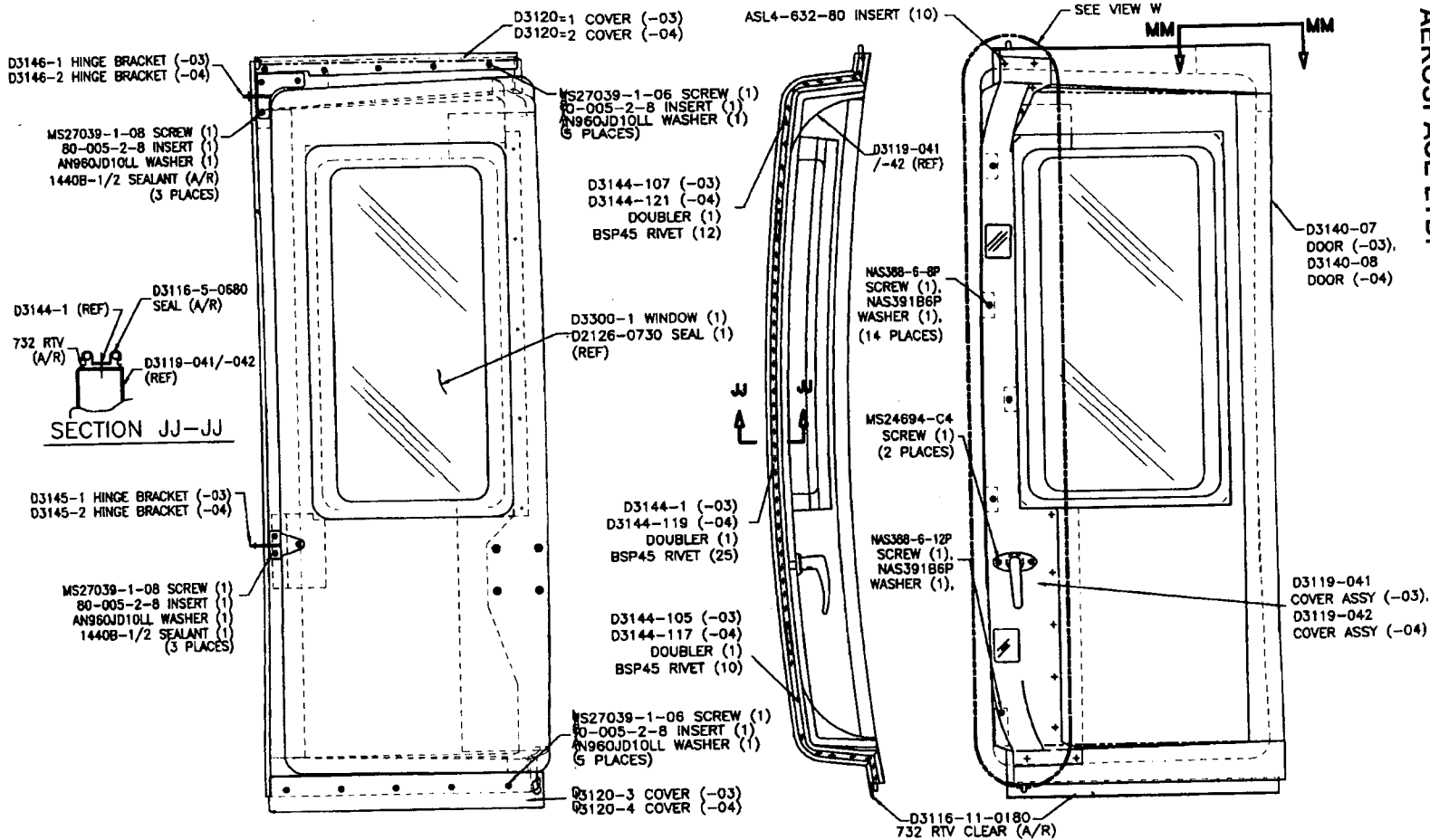
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D412-694-03 DOOR ASSY (SHOWN)
D412-694-04 DOOR ASSY (OPP)

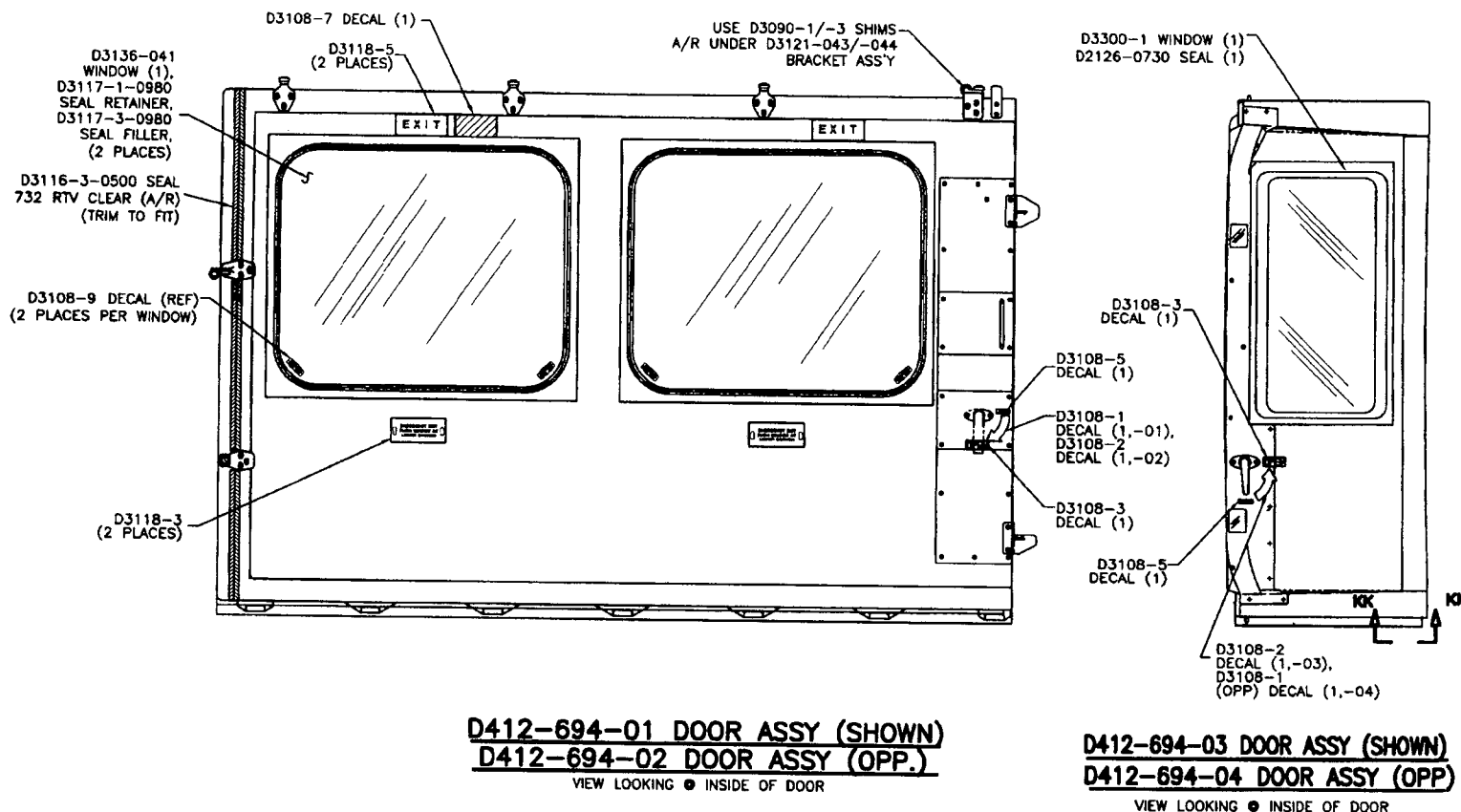
FIGURE 5: Replacement Parts, D412-694-03/-04 Door Assembly

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FIGURE 2: Decal Installation



NOTE: THE PARTS LABELLED IN THIS DIAGRAM ARE INSTALLED BY THE CUSTOMER AFTER PAINT.
ALL OTHER PARTS COME PRE-ASSEMBLED ON THE DOOR.

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Date: 04.10.07

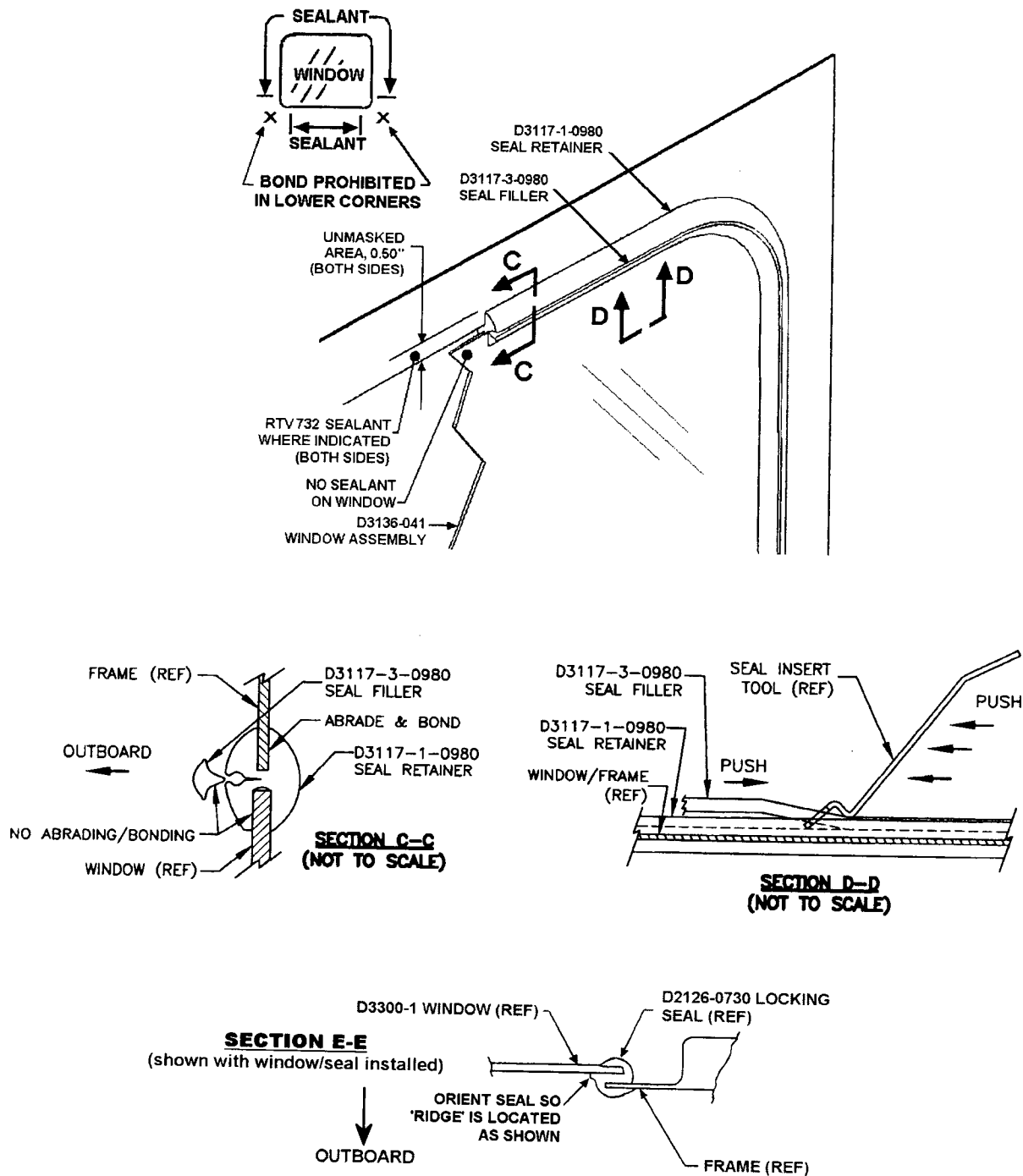
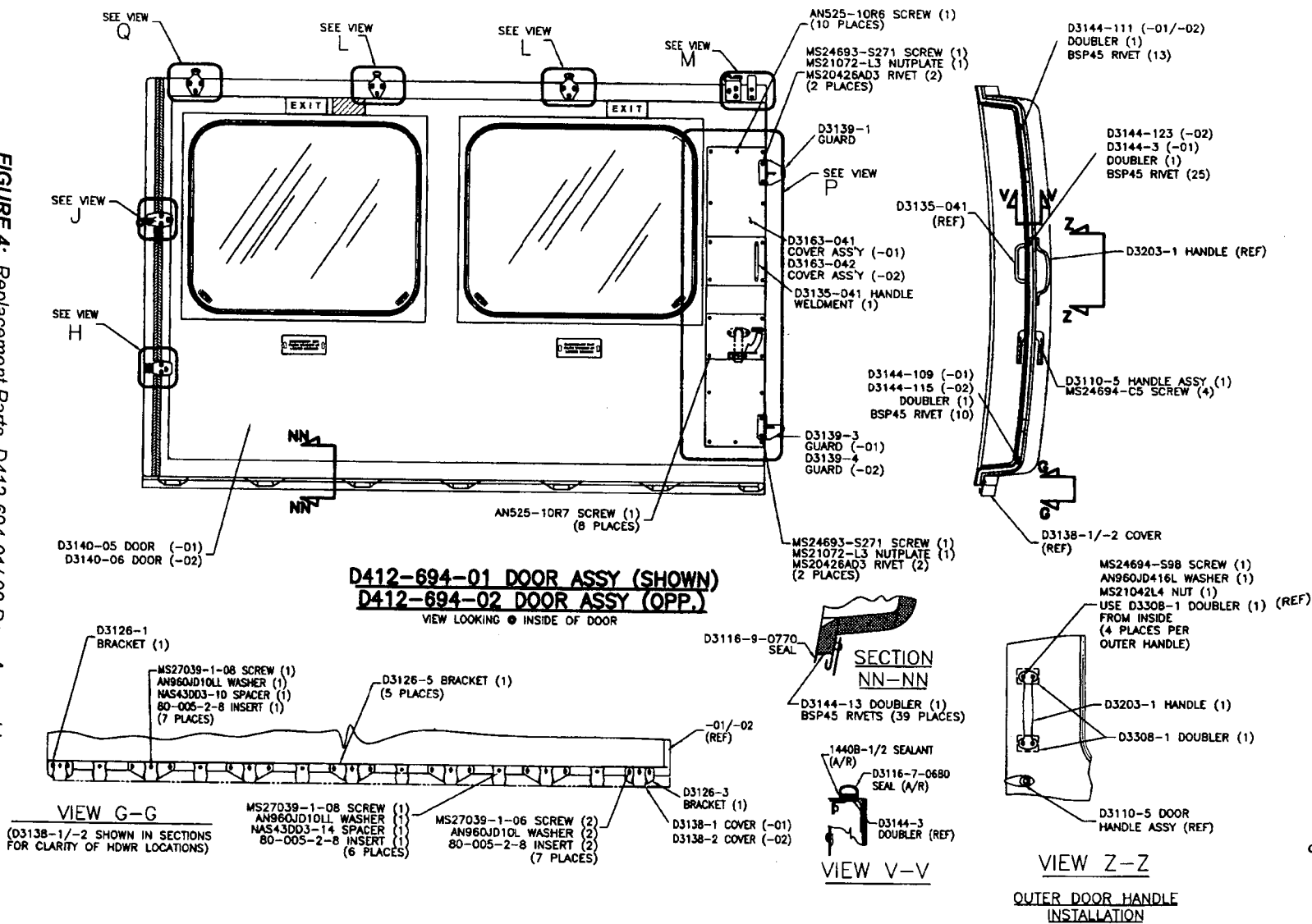


FIGURE 3: window/Seal Installation, (D412-694-01/-02 Door Assembly)

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FIGURE 4: Replacement Parts, D412-694-01/-02 Door Assembly

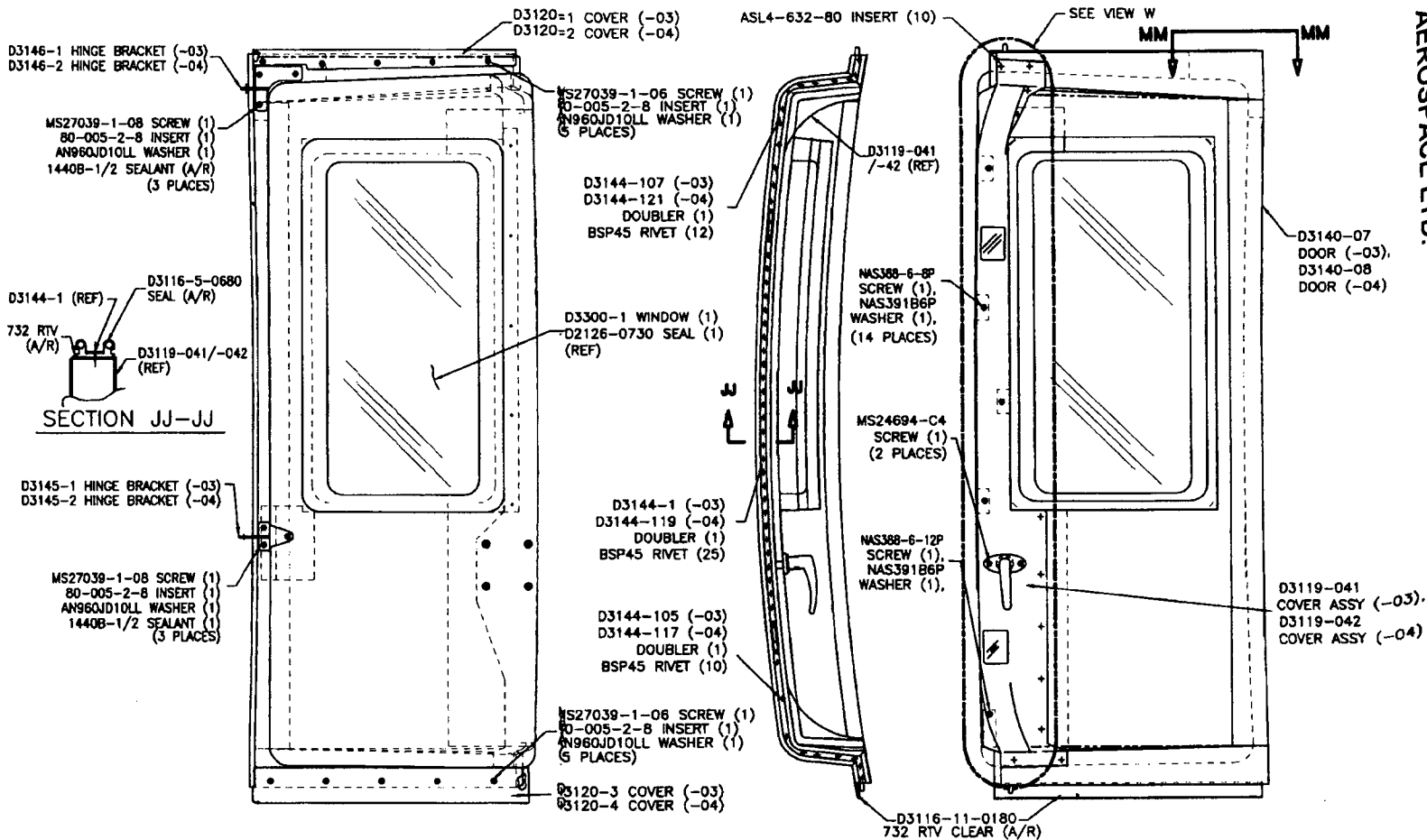


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D412-694-03 DOOR ASSY (SHOWN)
D412-694-04 DOOR ASSY (OPP)

FIGURE 5: Replacement Parts, D412-694-03/04 Door Assembly

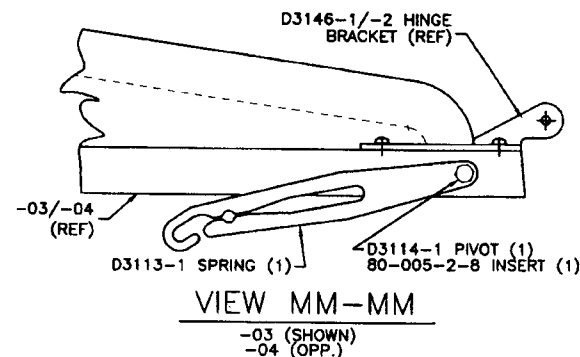
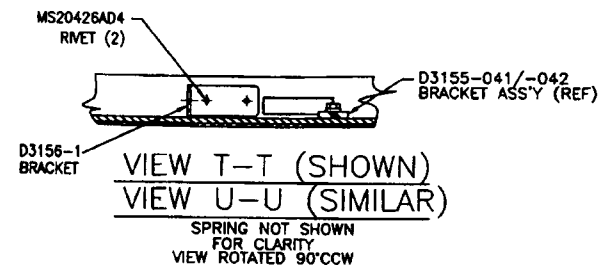
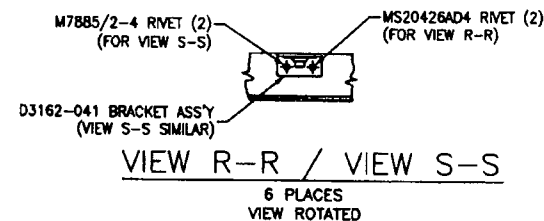
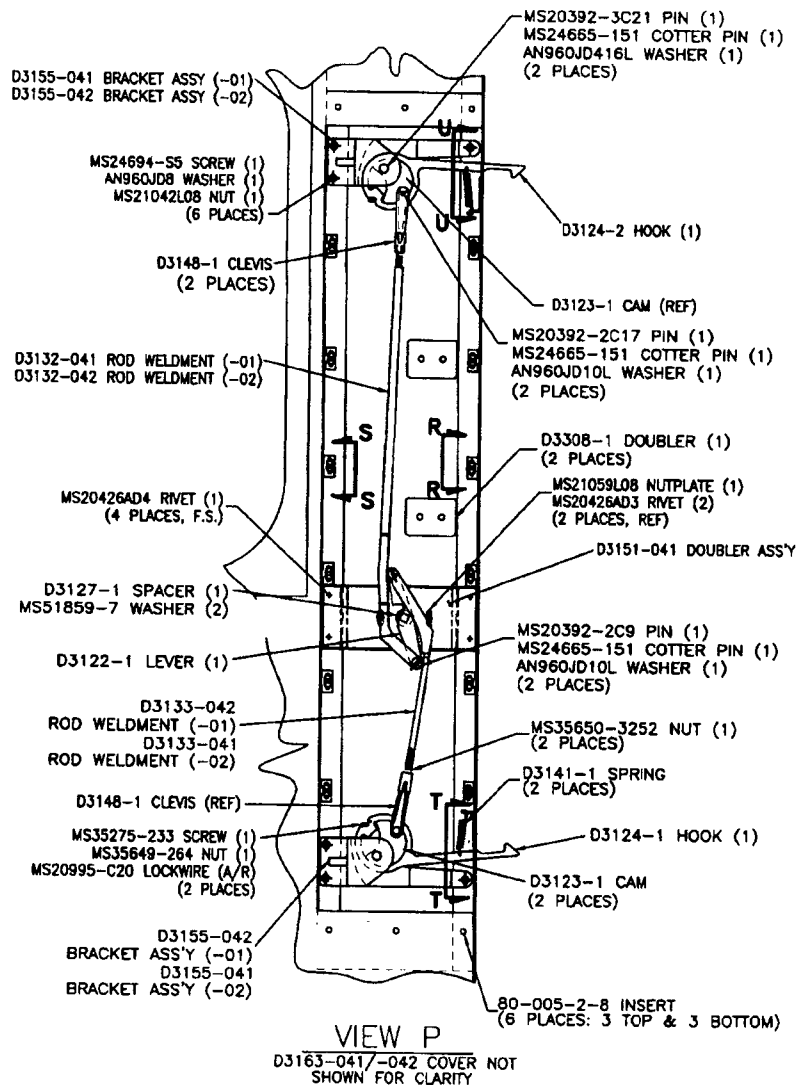
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FIGURE 6: Replacement Parts, Door Assembly Details



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Date: 04.10.07

FIGURE 7: Replacement Parts, Door Assembly Details

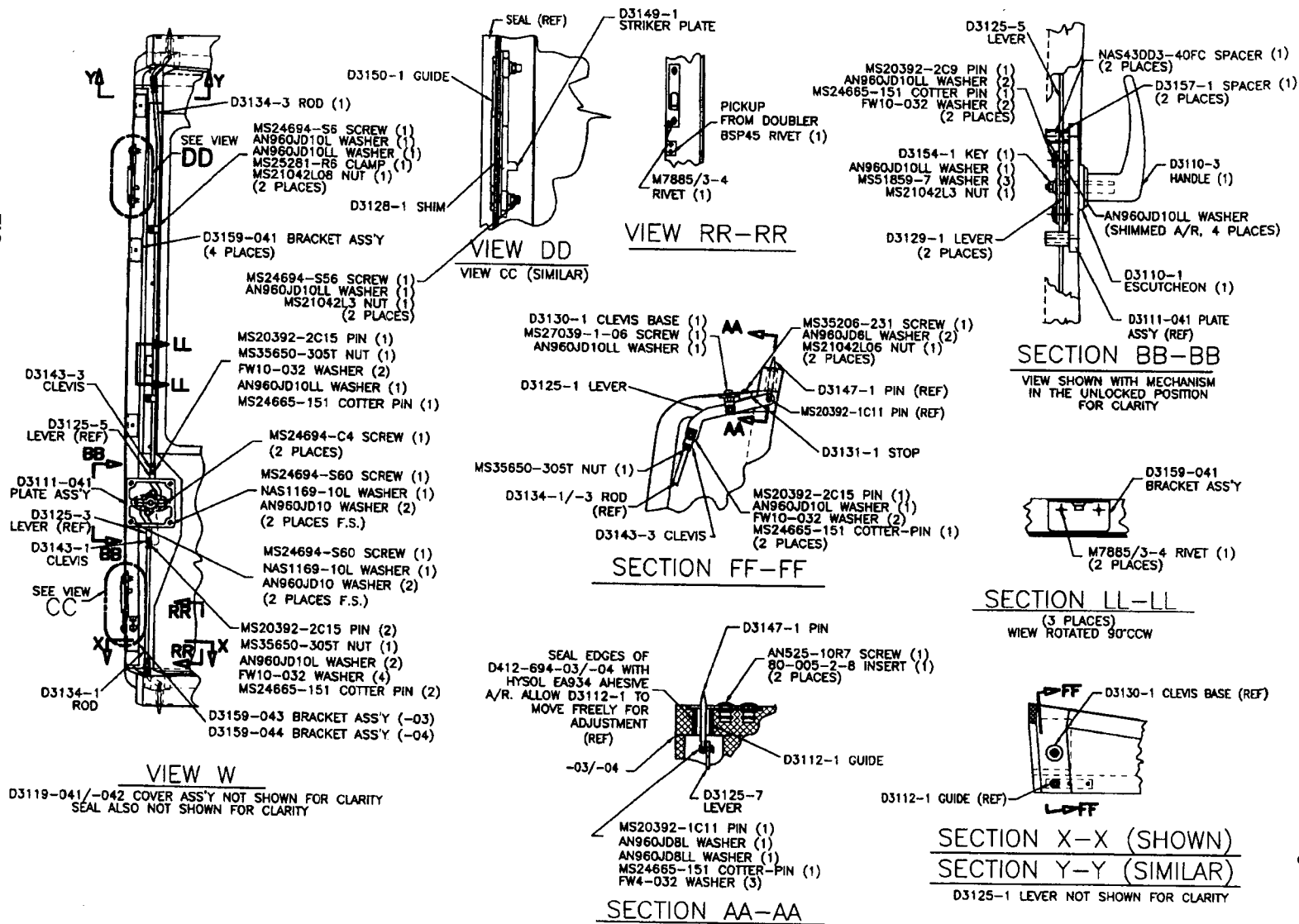
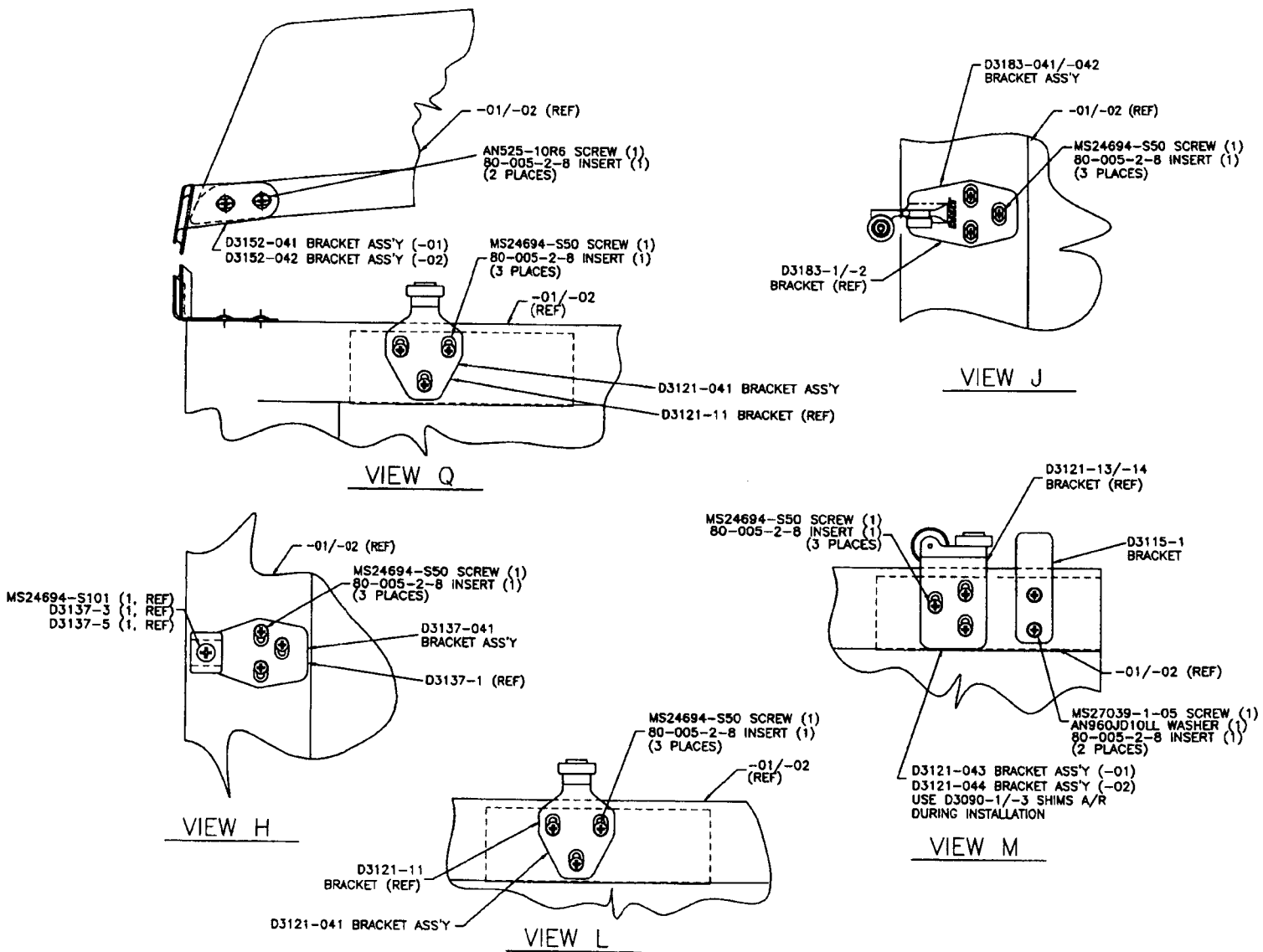


FIGURE 8: Replacement Parts, Door Assembly Details

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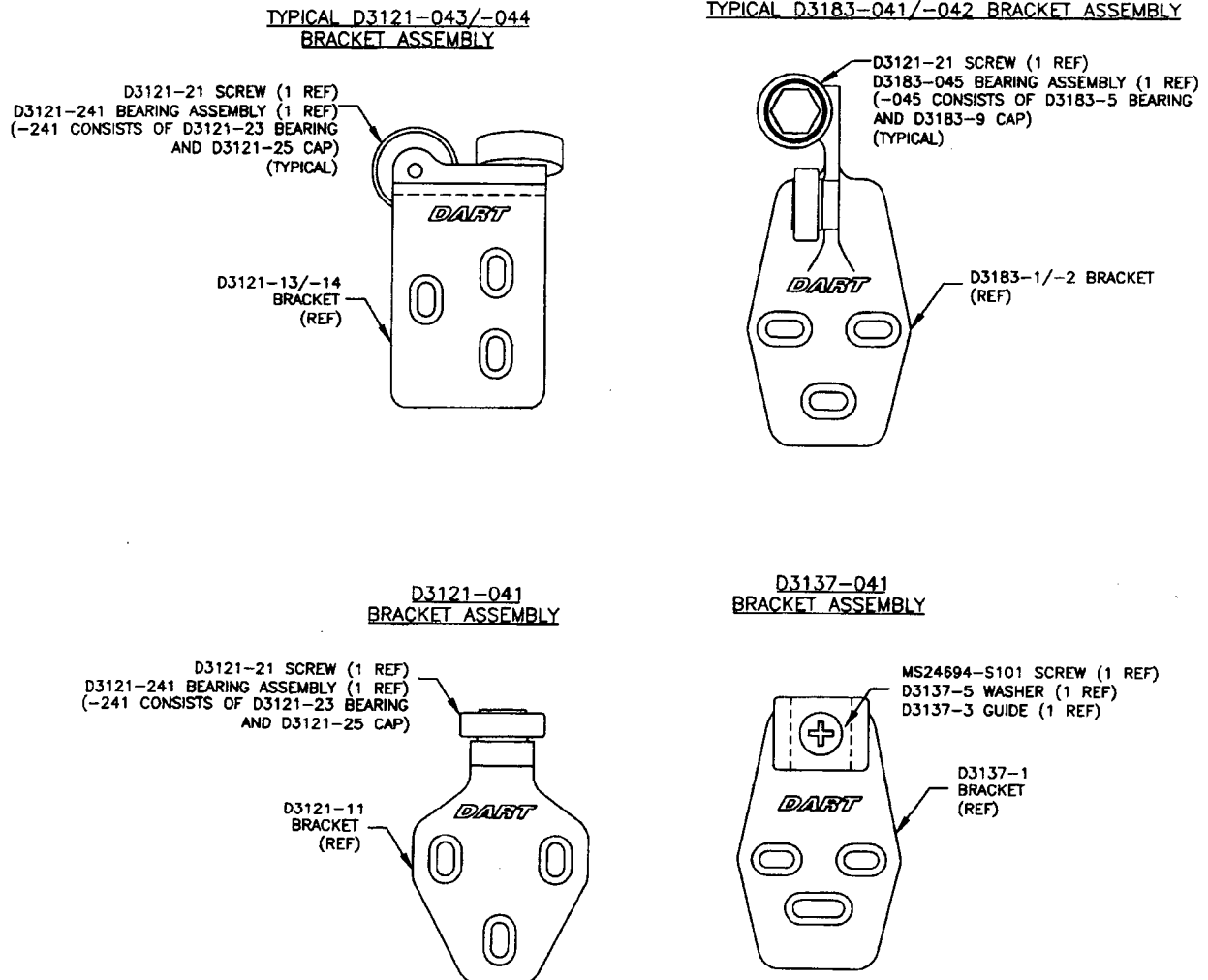


FIGURE 9: Replacement Parts, D412-694-01/-02 Door Assembly

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Date: 04.10.07

6. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X								D412-694-011	SPACEDOOR™ INSTALLATION
	X							D412-694-013	PANEL INSTALLATION (OPTIONAL)
4		X						D412-694-015	REPLACEMENT WINDOW KIT
			X					D412-694-017	BEARING OVERHAUL KIT
1				X				D412-694-01	DOOR ASSEMBLY
1					X			D412-694-02	DOOR ASSEMBLY
1						X		D412-694-03	DOOR ASSEMBLY
1							X	D412-694-04	DOOR ASSEMBLY
2								D2126-0730	SEAL
4								D3090-1	SHIM
4								D3090-3	SHIM
2								D3108-1	DECAL
2								D3108-2	DECAL
4								D3108-3	DECAL
4								D3108-5	DECAL
2								D3108-7	DECAL
						1	1	D3110-1	ESCUTCHEON
						1	1	D3110-3	HANDLE
				1	1			D3110-5	HANDLE ASSEMBLY
						1	1	D3111-041	PLATE ASSEMBLY
						2	2	D3112-1	GUIDE
						1	1	D3113-1	SPRING
						1	1	D3114-1	PIVOT
				1	1			D3115-1	BRACKET
2								D3116-1-0500	SEAL
						1	1	D3116-11-0180	SEAL
2								D3116-3-0500	SEAL
						1	1	D3116-5-0680	SEAL
				1	1			D3116-7-0680	SEAL
				1	1			D3116-9-0770	SEAL
		1						D3117-1-0980	SEAL RETAINER
		1						D3117-3-0980	SEAL FILLER
4								D3118-3	SIGN ASSEMBLY
4								D3118-5	SIGN ASSEMBLY
						1		D3119-041	COVER ASSEMBLY
							1	D3119-042	COVER ASSEMBLY
						1		D3120-1	COVER
							1	D3120-2	COVER
						1		D3120-3	COVER
							1	D3120-4	COVER
				3	3			D3121-041	BRACKET ASSEMBLY ("ROLLER")
				1				D3121-043	BRACKET ASSEMBLY ("ROLLER")
					1			D3121-044	BRACKET ASSEMBLY ("ROLLER")
			7					D3121-21	SCREW

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Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
			5					D3121-241	BEARING ASSEMBLY
				1	1			D3122-1	LEVER
				2	2			D3123-1	CAM
				1	1			D3124-1	HOOKE
				1	1			D3124-2	HOOKE
						1	1	D3125-1	LEVER
						1	1	D3125-3	LEVER
						1	1	D3125-5	LEVER
						1	1	D3125-7	LEVER
				1	1			D3126-1	BRACKET ("SLIDER")
				1	1			D3126-3	BRACKET ("SLIDER")
				5	5			D3126-5	BRACKET ("SLIDER")
				1	1			D3127-1	SPACER
						1	1	D3128-1	SHIM
						2	2	D3129-1	LEVER
						2	2	D3130-1	CLEVIS BASE
						1	1	D3131-1	STOP
				1				D3132-041	ROD WELDMENT
					1			D3132-042	ROD WELDMENT
					1			D3133-041	ROD WELDMENT
				1				D3133-042	ROD WELDMENT
						1	1	D3134-1	ROD
						1	1	D3134-3	ROD
				1	1			D3135-041	HANDLE WELDMENT
		1						D3136-041	WINDOW ASSEMBLY
				2				D3137-041	BRACKET ASSEMBLY ("ROLLER")
			1					D3137-3	GUIDE
			1					D3137-5	WASHER
				1				D3138-1	COVER
					1			D3138-2	COVER
				1	1			D3139-1	GUARD
				1				D3139-3	GUARD
					1			D3139-4	GUARD
				1				D3140-05	DOOR
					1			D3140-06	DOOR
						1		D3140-07	DOOR
							1	D3140-08	DOOR
				2	2			D3141-1	SPRING
						1	1	D3143-1	CLEVIS
						3	3	D3143-3	CLEVIS
						1		D3144-1	DOUBLER
						1		D3144-105	DOUBLER
						1		D3144-107	DOUBLER
				1				D3144-109	DOUBLER
				1	1			D3144-111	DOUBLER
					1			D3144-115	DOUBLER
							1	D3144-117	DOUBLER
							1	D3144-119	DOUBLER

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Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
							1	D3144-121	DOUBLER
					1			D3144-123	DOUBLER
				1	1			D3144-13	DOUBLER
				1				D3144-3	DOUBLER
						1		D3145-1	HINGE BRACKET
							1	D3145-2	HINGE BRACKET
						1		D3146-1	HINGE BRACKET
							1	D3146-2	HINGE BRACKET
						2	2	D3147-1	PIN
				2	2			D3148-1	CLEVIS
						2	2	D3149-1	STRIKER PLATE
						2	2	D3150-1	GUIDE
				1	1			D3151-041	DOUBLER ASSEMBLY
				1				D3152-041	BRACKET ASSEMBLY
					1			D3152-042	BRACKET ASSEMBLY
	1							D3153-11	PANEL
	1							D3153-12	PANEL
	1							D3153-13	PANEL
	1							D3153-14	PANEL
	1							D3153-15	PANEL
	1							D3153-16	PANEL
						1	1	D3154-1	KEY
				1	1			D3155-041	BRACKET ASSEMBLY
				1	1			D3155-042	BRACKET ASSEMBLY
				2	2			D3156-1	BRACKET
						2	2	D3157-1	SPACER
						3	3	D3159-041	BRACKET ASSEMBLY
						1		D3159-043	BRACKET ASSEMBLY
							1	D3159-044	BRACKET ASSEMBLY
				12	12			D3162-041	BRACKET ASSEMBLY
				1				D3163-041	COVER ASSEMBLY
					1			D3163-042	COVER ASSEMBLY
				1				D3183-041	BRACKET ASSEMBLY ("ROLLER")
					1			D3183-042	BRACKET ASSEMBLY ("ROLLER")
			2					D3183-045	BEARING ASSEMBLY
				1	1			D3203-1	HANDLE ASSEMBLY
2								D3300-1	WINDOW
				2	2			D3308-1	DOUBLER
				55	55	21	21	80-005-2-8	INSERT (OR SL2052-3-4)
	60							A6K75	RIVNUT
				10	10			AN525-10R6	SCREW
				8	8	4	4	AN525-10R7	SCREW
						8	8	AN960JD10	WASHER
				18	18	4	4	AN960JD10L	WASHER
				13	13	32	32	AN960JD10LL	WASHER
				6	6			AN960JD416L	WASHER
						4	4	AN960JD6L	WASHER
				6	6			AN960JD8	WASHER
						2	2	AN960JD8L	WASHER

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Revision: B

Date: 04.10.07

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
						2	2	AN960JD8LL	WASHER
						10	10	ASL4-632-80	INSERT
				87	87	47	47	BSP45	RIVET
						14	14	FW10-032	WASHER
						6	6	FW4-032	WASHER
				12	12			M7885/2-4	RIVET (OR CR3213-4-3)
						3	3	M7885/3-4	RIVET (OR CR3212-4-3)
						2	2	MS20392-1C11	PIN
						5	5	MS20392-2C15	PIN
				2	2			MS20392-2C17	PIN
				2	2	2	2	MS20392-2C9	PIN
				2	2			MS20392-3C21	PIN
				8	8			MS20426AD3	RIVET
				20	20			MS20426AD4	RIVET
				A/R	A/R			MS20995-C20	LOCKWIRE
						6	6	MS21042L06	NUT
				6	6	2	2	MS21042L08	NUT
						5	5	MS21042L3	NUT
				4	4			MS21042L4	NUT
				4	4			MS21072-L3	NUTPLATE
				6	6	9	9	MS24665-151	COTTER PIN
				4	4			MS24693-S271	SCREW
						2	2	MS24694-C4	SCREW
				4	4			MS24694-C5	SCREW
			1					MS24694-S101	SCREW
				6	6			MS24694-S5	SCREW
				18	18			MS24694-S50	SCREW
						4	4	MS24694-S56	SCREW
						2	2	MS24694-S6	SCREW
						4	4	MS24694-S60	SCREW
				4	4			MS24694-S98	SCREW
						2	2	MS25281-R6	CLAMP
				2	2	2	2	MS27039-1-05	SCREW
				14	14	12	12	MS27039-1-06	SCREW
				13	13	6	6	MS27039-1-08	SCREW
						2	2	MS35206-231	SCREW
				2	2			MS35275-233	SCREW
				2	2			MS35649-264	NUT
						4	4	MS35650-305T	NUT
				2	2			MS35650-3252	NUT
				2	2	3	3	MS51859-7	WASHER
						4	4	NAS1169-10L	WASHER
						1	1	NAS388-6-12P	SCREW
	60					14	14	NAS388-6-8P	SCREW
	60					15	15	NAS391B6P	WASHER
				7	7			NAS43DD3-10	SPACER
				6	6			NAS43DD3-14	SPACER
						2	2	NAS43DD3-40	SPACER

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9314	REV. A SHEET 1 OF 3
DATE 05.11.11		TITLE BRACKET MODIFICATION KIT	SCALE NTS
A	05.11.11	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-694 REV. B
REF. CANADIAN STC: SH05-10
REF. FAA STC: SR02086NY

For the D412-694-01/-02 Door Assembly, if the travel of the D3110-5 Handle Assembly interferes with the D3133-041/-042 Rod Weldment or nutplate on the D3162-041 Bracket Assembly, it is acceptable to install the DSI 9314-011 Kit to correct this problem. The DSI 9314-011 Kit may be installed on D412-694-01/-02 Door Assemblies at CHG003 or earlier change numbers. This modification should be performed per the procedure below and figures 1 & 2 of this document.

CUSTOMERS WITH EARLY MODEL D412-694-011 KITS CAN PROCURE THE DSI 9314-011 KIT FROM DART TO DO THIS MODIFICATION.

-Qty	Part Number	Description
X	DSI 9314-011	BRACKET MODIFICATION KIT
4	D3162-043	BRACKET ASSEMBLY
4	D3162-044	BRACKET ASSEMBLY
1	D3163-041	COVER ASSEMBLY
1	D3163-042	COVER ASSEMBLY
30	BSP45	RIVET
8	M7885/2-4-3	RIVET
8	MS20426AD4-7	RIVET

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 05.11.11
CERT. NO.: SH05-10
ISSUE NO.: 1

PROCEDURE:

- 1) From the D412-694-01/-02 Door Ass'y, remove D3163-041/-042 Cover Assembly and enough of the rivets securing the D3144-3 Doubler (-01 Door Ass'y) or D3144-123 Doubler (-02 Door Ass'y) so that the rivets attaching the D3162-041 Brackets can be accessed (see Figure 2).
- 2) Remove D3162-041 Bracket Assembly in 4 places as shown in Figure 1.
- 3) Transfer holes from the existing D3163-041/-042 Cover Assembly to the replacement cover assembly except do not transfer the 4 holes used to secure the D3162-041 Bracket in step 2 of this service instruction.
- 4) Locate holes in D3163-041/-042 as shown in Figure 2 to help properly locate D3162-043/-044 as shown in Figure 1. Transfer drill the 2 existing #30 diameter holes (used to fasten the removed D3162-041) from the door to each D3162-043/-044 Bracket Ass'y as shown in Figure 1. Touch up with Alodine per MIL-C-5541 and match original finish.
- 5) Install D3162-043/-044 Bracket Assembly as shown in Figure 1. If necessary fill any holes remaining that would be visible from the exterior of the door with Hysol EA934NA or equivalent. Touch up with Grey Primer 1144-S or equivalent and match original finish.
- 6) Re-install D3144-123/D3144-3 Doubler using BSP45 rivets.
- 7) Transfer D3139-1/-3/-4 Guard, D3135-041 Handle Weldment & D3110-5 Handle Ass'y and hardware from existing cover to the new D3163-041/-042 Cover Assembly per IIN-D412-694.
- 8) Re-install D3163-041/-042 Cover Assembly per IIN-D412-694.

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CHECKED 	APPROVED 	DRAWING NO. DSI 9314		SHEET 2 OF 3
DATE 05.11.11		TITLE BRACKET MODIFICATION KIT		SCALE NTS

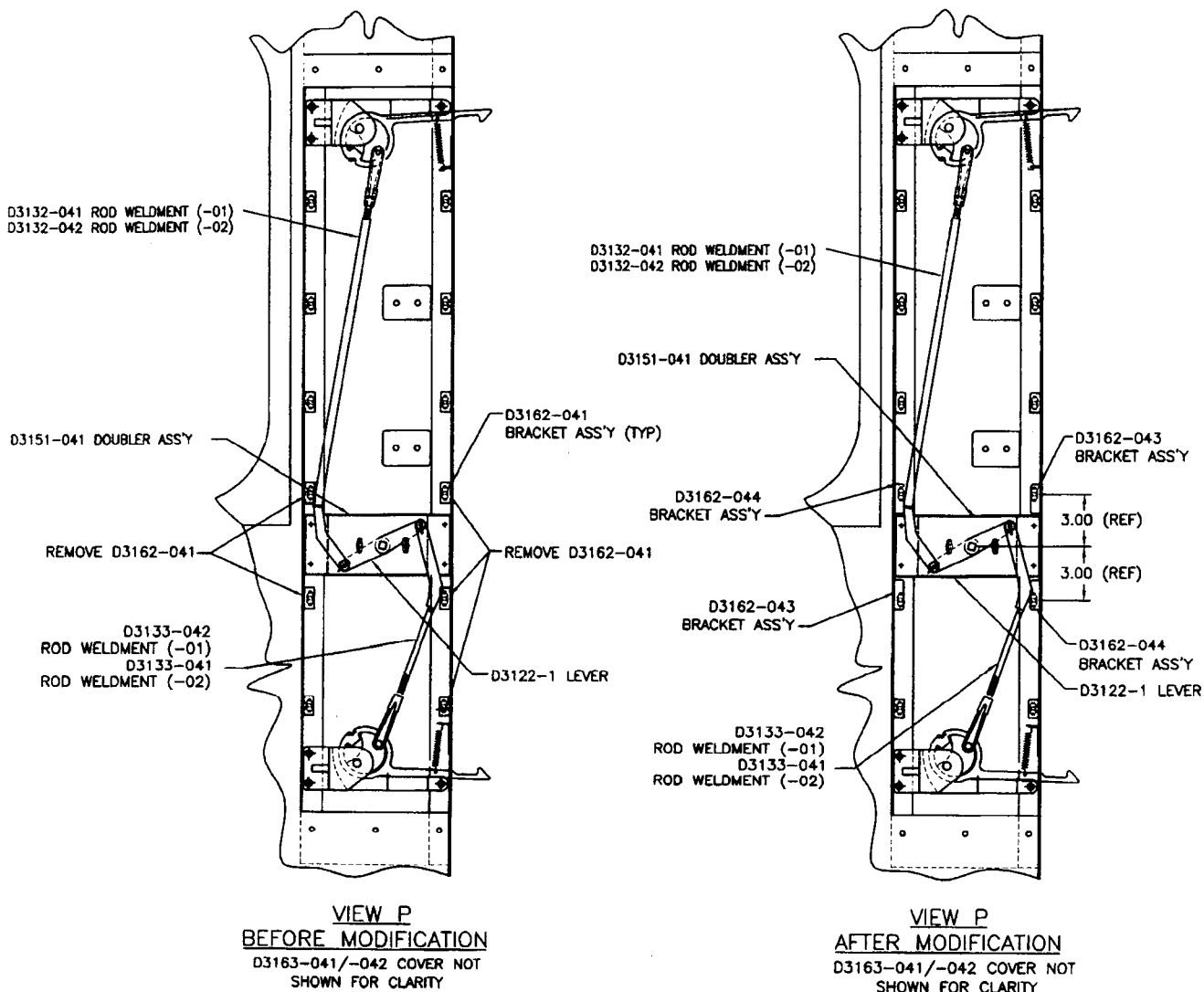


FIGURE 1

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:
D. SHEPHERD (DE # 02)

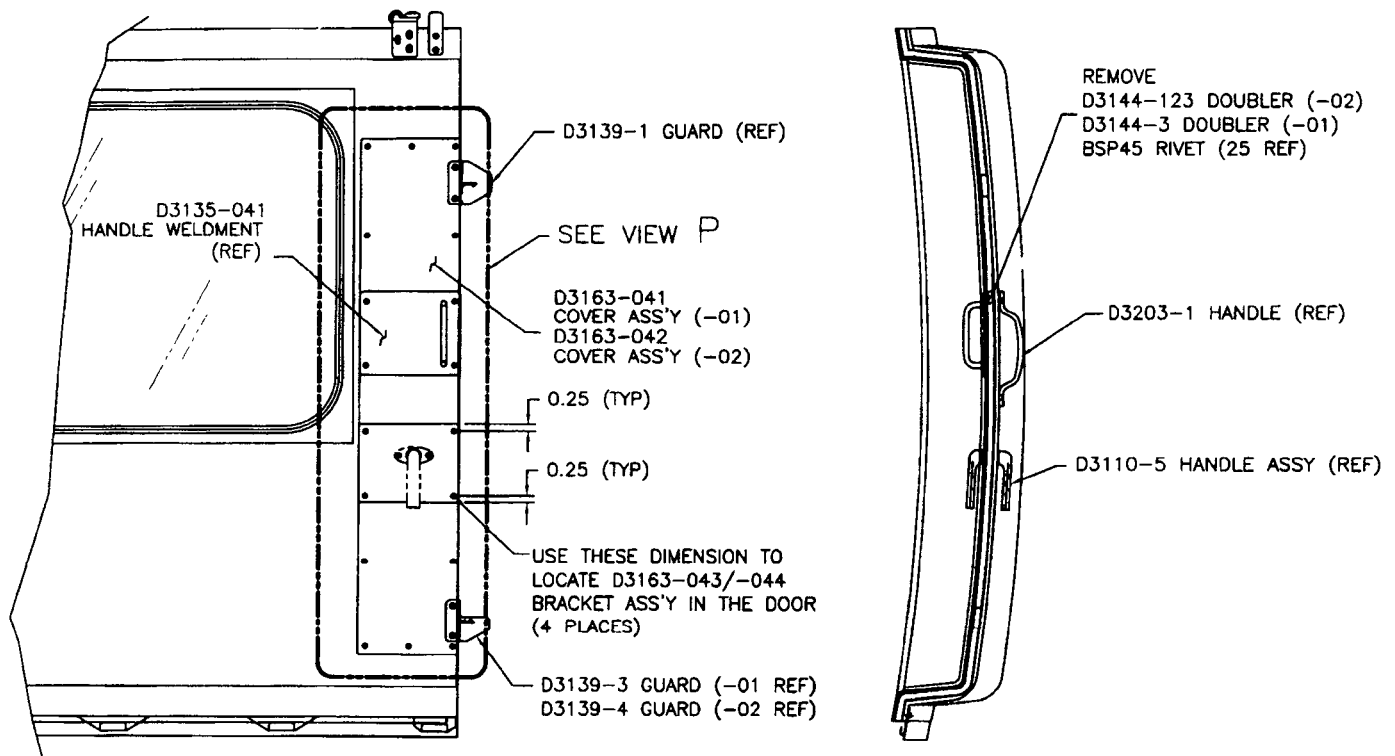
DATE: 05.11.11
CERT. NO.: SH05-10
ISSUE NO.: 1

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9314	REV. A SHEET 3 OF 3
DATE 05.11.11	TITLE BRACKET MODIFICATION KIT		SCALE NTS



D412-694-01 DOOR ASSY (SHOWN)
D412-694-02 DOOR ASSY (OPP.)
VIEW LOOKING • INSIDE OF DOOR

FIGURE 2

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO #01-O-01	
APPROVED	
BY:	<i>[Signature]</i> D. SHEPHERD (DE # 02)
DATE:	05.11.11
CERT. NO.:	SH05-10
ISSUE NO.:	1

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CHECKED 	APPROVED 	DRAWING NO. DSI 9316	REV. A SHEET 1 OF 1
DATE 05.12.12		TITLE PART SUBSTITUTION	SCALE NTS
A	05.12.12	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D412-694 REV. B

REF. CANADIAN STC: SH05-10

REF. FAA STC: SR02086NY

ON D412-694-011 AT CHG 005 OR LATER

D3137-045 BRACKET ASSEMBLY

REPLACES

D3137-041 BRACKET ASSEMBLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:
D. SHEPHERD (DE # 02)

DATE: 05.12.12
CERT. NO.: SH05-10
ISSUE NO.: 1

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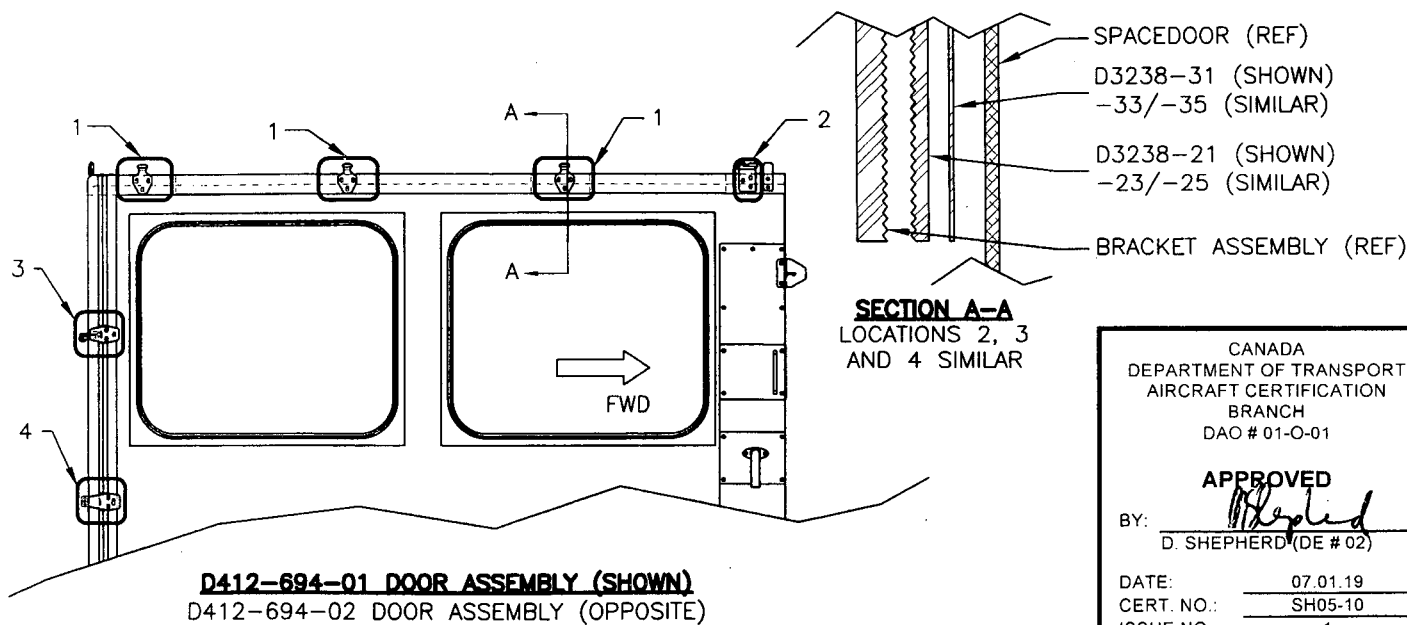
PART SERVICE INSTRUCTIONS
TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-694 REV. B AND INSTRUCTIONS FOR CONTINUED
AIRWORTHINESS ICA-D412-694 REV. 1
 REF. CANADIAN STC: SH05-10
 REF. FAA STC: SR02086NY

Dart has created the optional DSI-9363-011 Shim Kit that may be installed between the D3121-041/-043/-044, D3183-041/-042 and D3137-041 Bracket Assemblies and the Spacedoor™ to improve grip between the Bracket Assemblies and the Spacedoor™. This kit may be installed as a replacement for or in addition to the AN960JD10 Washers and/or the D3090-1/-3 Shims used to shim the Bracket Assemblies as described in the Installation Instructions.

The serrated faces of the D3238-21/-23/-25 Plates should be installed against the serrated faces of the Bracket Assemblies to ensure positive locking as shown in **Section A-A**. The D3238-31/-33/-35 Plates, the AN960JD10 Washers and the D3090-1/-3 Shims can be installed as required between the D3238-21/-23/-25 Plates and the Spacedoor™ to achieve good door alignment.

The Table and Figure below show the location, the quantity and the part number of each Plate and the corresponding Bracket Assemblies on the Spacedoor™.

Qty	Part Number	Description	Used to Shim Bracket Assembly P/Ns	Location
X	DSI-9363-011	SHIM KIT		
6	D3238-21	PLATE	D3121-041	1
12	D3238-31	PLATE	D3121-041	1
2	D3238-23	PLATE	D3121-043/-044	2
4	D3238-33	PLATE	D3121-043/-044	2
4	D3238-25	PLATE	D3183-041/-042, D3137-041	3, 4
8	D3238-35	PLATE	D3183-041/-042, D3137-041	3, 4



CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i> D. SHEPHERD (DE # 02)
DATE:	07.01.19
CERT. NO.:	SH05-10
ISSUE NO.:	1

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13236
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
19/11/2009	22/09/2009	6041	Chantal Lavoie		PO10435		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC135-0019	LINE #1 D3140-06 Door Right Non Assy (Grosse) DWG D3140 REV. F Job: 22074			
1	0	1	DKC135-0020	LINE #2 D3140-08 Door Right Non Assy (Petite) DWG D3140 REV. F Job: 22074			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



ate: Mardi, 2009-09-22 11:40:28
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 22074

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.: Machine ou Opération: Description :

4.0 AMB0211 Epoxy prepreg E-761 style 7781

Commentair Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s)
Epoxy prepreg E-761 style 7781 N° de Lot: 1-24937-1

5.0 DECOUPE Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Découpe des tissus pré-impregné E-761 en paquet de 10.5 pi". (7 Paquet = 24.5 verges)

Quantité: 1 Date: 6-10-09 Sceau: NT.

6.0 DRAPAGE Drapage



Commentair Setup: 0.00Hrs/ Run: 720.0000Hrs Total Run : 720.0000Hrs

Faire le drapage de 3 plis de tissus E-761 (4 Paquets) selon IF135-0002

Quantité: 1 Date: 6-10-09 Sceau: NT.

7.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

8.0 AC0884 Wrighton 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

9.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

10.0 AC0882 Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

11.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

12.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le bagging sur la pièce selon IF135-0002 et IG 0012

Quantité: 1 Date: 7-10-09 Sceau: NT.

13.0 CUISSON Cuisson de pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20 N° de Cuisson: 6119

te: Mardi, 2009-09-22 11:40:28
lisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 22074

Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.: Machine ou Opération:

Description:

Quantité: 1 Date: 8/10/09 Sceau:

14.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Retirer le montage cuisson et faire les retouches de la pièces afin d'enlever les surplus de résines et les résidus de tissu à délaminer.

Quantité: 1 Date: 9/10/09 Sceau:

15.0

INSPECTION

Inspection générale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.

Quantité: 1 Date: 14 oct 09 Sceau:

16.0

AAC1618

Rohacell 71S 1"thick 49.2" x 98.4" plain

Commentair Qty.: 2.00 FEUILLE(s)/Unit Total : 2.00 FEUILLE(s)
Rohacell 71S 1"thick 49.2" x 98.4" plain N° de Lot: 1-24967-1 et 1-25513-1

17.0

DECOUPE

Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs

Faire la découpe des pièce de mousse structurales (Rohacell) sur la scie à ruban selon IF135-0002.

Quantité: 1 Date: 28/10/09 Sceau:

18.0

SÉCHAGE/ ANEAL

Séchage / Anealing



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le séchage du Rohacell selon IF135-0002 et les information du manufacturier. N° de Cuisson: 6133

Quantité: 1 Date: 26/10/09 Sceau:

ate: Mardi, 2009-09-22 11:40:28
tilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 22074

Numéro Article: DKC135-0019/-0020

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
19.0	AAC0560	PF-7035C supp.. film epoxy adhesive
Commentair Qty.: 55.00 PIED CARRE(s)/Unit Total : 55.00 PIED CARRE(s) PF-7035C supp.. film epoxy adhesive N° de Lot: <u>1-6534-1</u>		
20.0	AAC0559	Core splice adhesive MA560.048
Commentair Qty.: 5.00 PIED CARRE(s)/Unit Total : 5.00 PIED CARRE(s) Core splice adhesive MA560.048 N° de Lot: <u>1-7154-1</u>		
21.0	AAC0563	Epoxy Epocast 87269-A/B (4*2.9)
Commentair Qty.: 1 KIT(s)/Unit Total : 1 KIT(s) Epoxy Epocast 87269-A/B (4*2.9) N° de Lot: <u>AD-Tack P-17 1-24938-1</u>		
22.0	AAC1630	N° D3140-09, Doubler
Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) N° D3140-09, Doubler N° de Lot: <u>1-25506-11</u>		
23.0	AAC1631	N° D3140-87, Doubler
Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) N° D3140-87, Doubler N° de Lot: <u>1-25506-4</u>		
24.0	AAC1633	N° D3140-92, Doubler
Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) N° D3140-92, Doubler N° de Lot: <u>1-25506-5</u>		
25.0	AAC1634	N° D3140-95, Doubler
Commentair Qty.: 3 UNITE(s)/Unit Total : 3 UNITE(s) N° D3140-95, Doubler N° de Lot: <u>1-25506-6</u>		
26.0	AAC1636	N° D3140-98, Doubler
Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) N° D3140-98, Doubler N° de Lot: <u>1-25506-7</u>		
27.0	AAC1637	N° D3140-99, Doubler
Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) N° D3140-99, Doubler N° de Lot: <u>1-25506-8</u>		
28.0	AAC1638	N° D3140-101, Doubler
Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s) N° D3140-101, Doubler N° de Lot: <u>1-25506-1</u>		
29.0	AAC1640 AAC1639	N° D3140-104, Doubler
Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) N° D3140-104, Doubler N° de Lot: <u>1-25602-10</u>		
30.0	AAC1642 AAC1641	N° D3140-106, Doubler
Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) N° D3140-106, Doubler N° de Lot: <u>1-25602-11</u>		
31.0	AAC1643	N° D3140-241, Doubler
Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) N° D3140-241, Doubler N° de Lot: <u>1-25506-2</u>		

ate: Mardi, 2009-09-22 11:40:29
tilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 22074

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.: Machine ou Opération: Description:

32.0 AAC1645 N° D3140-303, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total: 2 UNITE(s)
N° D3140-303, Doubler N° de Lot: 1-25506-3

33.0 NETTOYAGE Nettoyage des pièces



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

Faire le nettoyage des doubliers selon IG 0063

Quantité: 1 Date: 28/10/09 Sceau:



34.0 ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 960.0Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Mise en place des doubliers et des pièces de mousse structurales selon IF135-0002

Quantité: 1 Date: 31/10/09 Sceau:



C.G.

35.0 AC0883

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)

36.0 AC0884

Wrighton 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)

37.0 AC0885

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)

38.0 AC0882

Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total: 7.770 VERGE(s)

39.0 AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total: 2.0000 ROULEAU(s)

40.0 BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run: 3.0000Hrs

Faire le montage cuisson selon IF135-0002 et IG 0012

Quantité: 1 Date: 31/10/09 Sceau:



41.0 CUISSON

Cuisson de pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs

Faire la cuisson de la pièces selon IF135-0002, IG 0012, et PTN #20 N° de Cuisson: 6/37

te: Mardi, 2009-09-22 11:40:29
lisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 22074

Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: 1

Date: 3/11/09

Sceau:



42.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson de sur la pièce et enlever les résidu de ruban adhésif en teflon et les barre d'aluminium, garder seulement la barre qui sépare les deux pièces.

Quantité: 1

Date: 4/11/09

Sceau:



43.0

DECOUPE

Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs

Usinage des mousse structurales selon IF135-0002 et installer les doublers

Quantité: 1

Date: 6/11/09

Sceau:



R.C.

44.0

INSPECTION

Inspection générale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étapes.

Quantité: 1

Date: 6-11-09

Sceau:



45.0

AMB0211

Epoxy prepreg E-761 style 7781

Commentair Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s)

Epoxy prepreg E-761 style 7781

N° de Lot: 1-25408-1

46.0

DRAPAGE

Drapage



Commentair Setup: 0.00Hrs/ Run: 720.0000Hrs Total Run : 720.0000Hrs

Drapage de la coquille intérieur selon IF135-0002

Quantité: 1

Date: 6-11-09

Sceau:



47.0

AC0883

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

ate: Mardi, 2009-09-22 11:40:29
utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 22074

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/-0020

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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48.0	AC0884	Wrightlon 5200 Bleu P3
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Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

49.0	AC0885	Feutre de drainage N° Airweave N 10
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Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

50.0	AC0882	Sac à vide N° Stretchlon 700
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Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

51.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
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Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

52.0	BAGGING	Faire le bagging sur la pièce
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Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0002 et IG 0012.

Quantité: 1 Date: 10-11-09 Sceau:



53.0	CUISSON	Cuisson de pièce
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Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièces selon IF135-0002, IG 0012, et PTN #20 N° de Cuisson: 6143

Quantité: 1 Date: 11-11-09 Sceau:



54.0	DÉMOULAGE	Démoulage de la pièce
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson et faire des retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissu à délaminer

Retirer la pièce du moule

Quantité: 1 Date: 13/11/09 Sceau:



55.0	INSPECTION	Inspection générale
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnel"

Quantité: 1 Date: 17/11/09 Sceau:



te: Mardi, 2009-09-22 11:40:29
ilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 22074

Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.: Machine ou Opération: Description :

56.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le trimage de finition de la pièce selon IF135-0003

Quantité: 1

Date: 17/09/09

Sceau:



N/A

57.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 2-25136-3

58.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-24359-3

59.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire l'application du primer selon IG 0008.

Quantité: 1

Date: 17/11/09

Sceau:



N° Fiche mélange: N/A

60.0

SABLAGE

Sablage



Commentair Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Faire le sablage du primer selon IF135-0003

Quantité: 1

Date: 18/09/09

Sceau:



Application primer

61.0

PRIMER



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire l'application du primer selon IG 0008.

Quantité: 1

Date: 18/11/09

Sceau:



N° Fiche mélange: N/A

62.0

IDENTIFICATION

Identification à encre indélébile



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'identification des pièces sur l'aluminium peinturé dans le dégagement des mécanisme de porte selon IG 0055.

ate:

Mardi, 2009-09-22 11:40:29

Utilisateur:

marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 22074

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

N° de pièce Grosse porte: D3140-06

N° de pièce Petite porte: D3140-08

N° de Job (sur les 2 pièces): 22074

Date de fabrication (sur les 2 pièces): 19 nov 09

Sceau d'inspection.

Quantité: 1

Date: 19 nov 09 Sceau:



63.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire l'inspection finale des pièces par le département de la qualité selon le dessin D3140.

Quantité: 1

Date: 19-11-09 Sceau:



64.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Emballer et entreposer selon IG 0057

Quantité: 1

Date: 19-11-09 Sceau:



Mardi, 2009-09-22 11:40:28

sateur: marc dubé

Feuille de Procédé

ent : DART US DART AEROSPACE LTD

Iméro Job : 22074

Iméro Soumission : 3407

Iméro B.A. :

ette fois : 2009-09-22 No. B.V. :

tst Rev. : NC

rem. fois : -- Type :

ob précédente :

crit par :

érifié & Approuvé par :

ommentaires :

Process Sheet Rév.: 01 Remplacer le Doubler Kit N° AAC1613 par
des N° de détails AAC1630, AAC1631, AAC1633, AAC1634,
AAC1636, AAC1637, AAC1638, AAC1640, AAC1642, AAC1643 &
AAC1645

Nom Dessin : DOOR KIT D.
Numéro Article : DKC135-0019/0020
Numéro Dessin : D3140
Projet Numéro : DK-359
Révision dessin : F
Matériel : Fibercote E-761
Date Dûe : 2009-09-29

Qté: 1 UdM: UNITE

Produit additionnel

Numéro Job:



Séq.:

Machine ou Opération:

Description :

1.0

OUTILLAGE

Outillage nécessaire pour la job



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Moule N° B30-23000-01T

Patron de découpe N° B30-23000-57T

Patron de découpe N° B30-23000-61T

Patron de découpe N° B30-23000-63T

Patron de découpe N° B30-23000-71T

Patron de découpe N° B30-23000-73T

Patron de découpe N° B30-23000-75T

Patron de découpe N° B30-23000-77T

Patron de découpe N° B30-23000-79T

Gabarit de taillage N° B30-23000-06T (2 pièce) et N° B30-2300-03T

Forme de silicone N° B30-23000-08T

2.0

AAC0854

Frekote #700-NC

Commentair Qty.: 0.030 UNITE(s)/Unit Total : 0.030 UNITE(s)

Frekote #700-NC

N° de Lot: 1-7095-1

3.0

PRÉPARATION

Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 130.0000Min Total Run : 2.1667Hrs

Faire la préparation du moule selon IF135-0002 et IG 0009